Abstract

In adjusting phase for work (W), the operation of mounting/dismounting a reference tool on a spindle (6) is dispensed with and so is a storage space for the reference tool, and besides, it is arranged that the thrust on the work (W) does not directly act on the spindle (6) at the time of this phase adjustment. In a machine tool in which a spindle housing (7) supporting the specifically directed spindle (6) for rotation alone is supported for parallel motion in orthogonal three-axis directions (XYZ) by a numerical control mechanism (4), in determining the phase for the work (W) is feed-rotated around a specific axis (S), it is arranged that with a reference block (9) fixed to the spindle housing (7), the work (W) is feed-rotated around the specific axis (S) to abut the phase reference section (W1) of the work against the reference block (9), so as to find the amount of feed-rotation of the work at the time of this abutment.